

Work Order ID 78316***78316***

Page 1

January-05-12 8:33:27 AM

Item ID: D3824-1KGY

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Hat Bin-Grey

Start Date: 05/01/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 19/01/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: M.L.JDate: 12/01/08 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3824	Rev C								

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

DL
12/01/09

105

0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°FTime IN: 7:00 pm 12/01/08Time OUT: 5:00 am 12/01/09DL
12/01/09

W/O:		WORK ORDER CHANGES					
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Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

0.00

110

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA033 using tool DT9405
Dwg Rev: C
Folio Rev: C

JK
12/01/09

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

JK
12/01/09

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

(2)

JB
12/01/09

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2

DH

12/01/11

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

x2

DH

12/01/11

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

S 12/01/11

(72)

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

15/1/24

12/1/24

PL 12-01-24
6

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Picklist Print

January-05-12 8:33:31 AM

Page 1

Work Order ID: 78316

78316

Parent Item: D3824-1KGY

D3824-1KGY

Parent Item Name: Hat Bin-Grey

Start Date: 05/01/2012

Required Date: 19/01/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.125-P3-52068		Purchased		No		100	sf	566.2486	11.41	22.83142			

MKYD6185S 125-P3-52068

Kydex steel grey

**

Location

therm

111807

111875

Loc Qty

566.24858

156.74858

409.5

Loc Code

22.83142 sq ft

12/01/11

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DART AEROSPACE LTD		Work Order: 78316
Description: Hat Bin		Part Number: D3824-1KIV/KGY
Inspection Dwg: D3824	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than $\frac{1}{8}$ "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Dh Date: 12/01/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	+0.05/-0.00	0.423"	✓		Varn DL-02	
48.5	Ref	48.5"	✓		TAPE DL-01	
34.1	Ref	34.0"	✓		TAPE DL-01	
41.6	Ref	41.56"	✓		TAPE DL-01	
3.5	Ref	3.5"	✓		TAPE DL-01	
0.055	Min	0.111"	✓		ULTRA	
0.030	MIN	0.048"	✓		ULTRA	

Measured by: Dh Date: 12/01/11

Audited by: S Date: 12/01/16

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.06.26	New Issue	KJ <u>gg</u>	<u>MA</u>

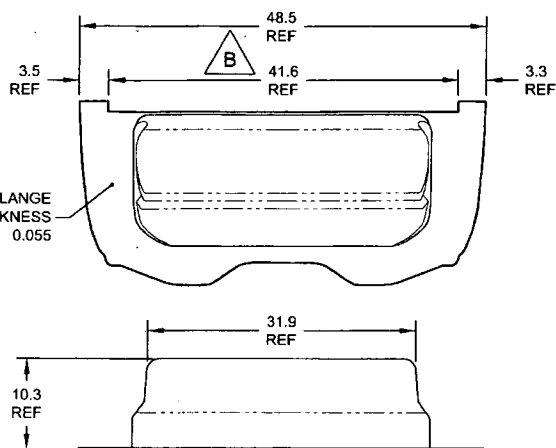
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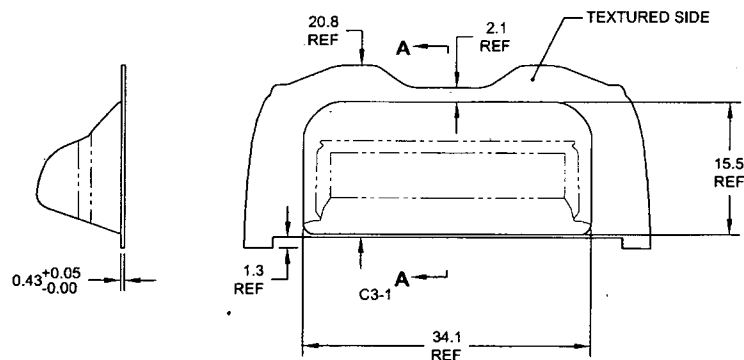
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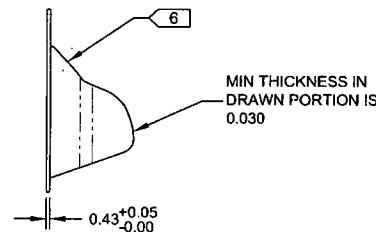
NOTE: Date & initial all entries



SECTION A-A
SCALE 2X

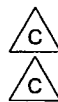


D3824-1 HAT BIN
(BELL 206 A/B)



NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 5.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9405 PER DART QSI 022. TRIM PER MOLD



PART NUMBER	DESCRIPTION
D3824-1KIV	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3824-1KGY	KYDEX 6185, 0.125 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

C	ADD STEEL GRAY COLOUR OPTION, ADD IVORY P/N'S D3824-1KIV, D3824-3KIV AND ADD STEEL GRAY P/N'S D3824-1KGY, D3824-3KGY (ZN A5-1, A5-2)	PH	09.05.05
B	0.125 THICK WAS 0.080 (ZN A7-1, A7-2) REASON: TO IMPROVE DURABILITY: MODIFY WIDTH TO ALLOW FOR BETTER FIT WITH A/C (ZN D6-1, D6-2)	PH	09.02.19
A	NEW ISSUE	PH	08.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.05.05		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C
D3824 SHEET 1 OF 2
TITLE HAT BIN (BELL 206 A/B) SCALE NTS

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SUBJECT TO CHANGE
W/OUT NOTICE
NO 78316-MLO
12/01/05

RELEASED
9/25/22

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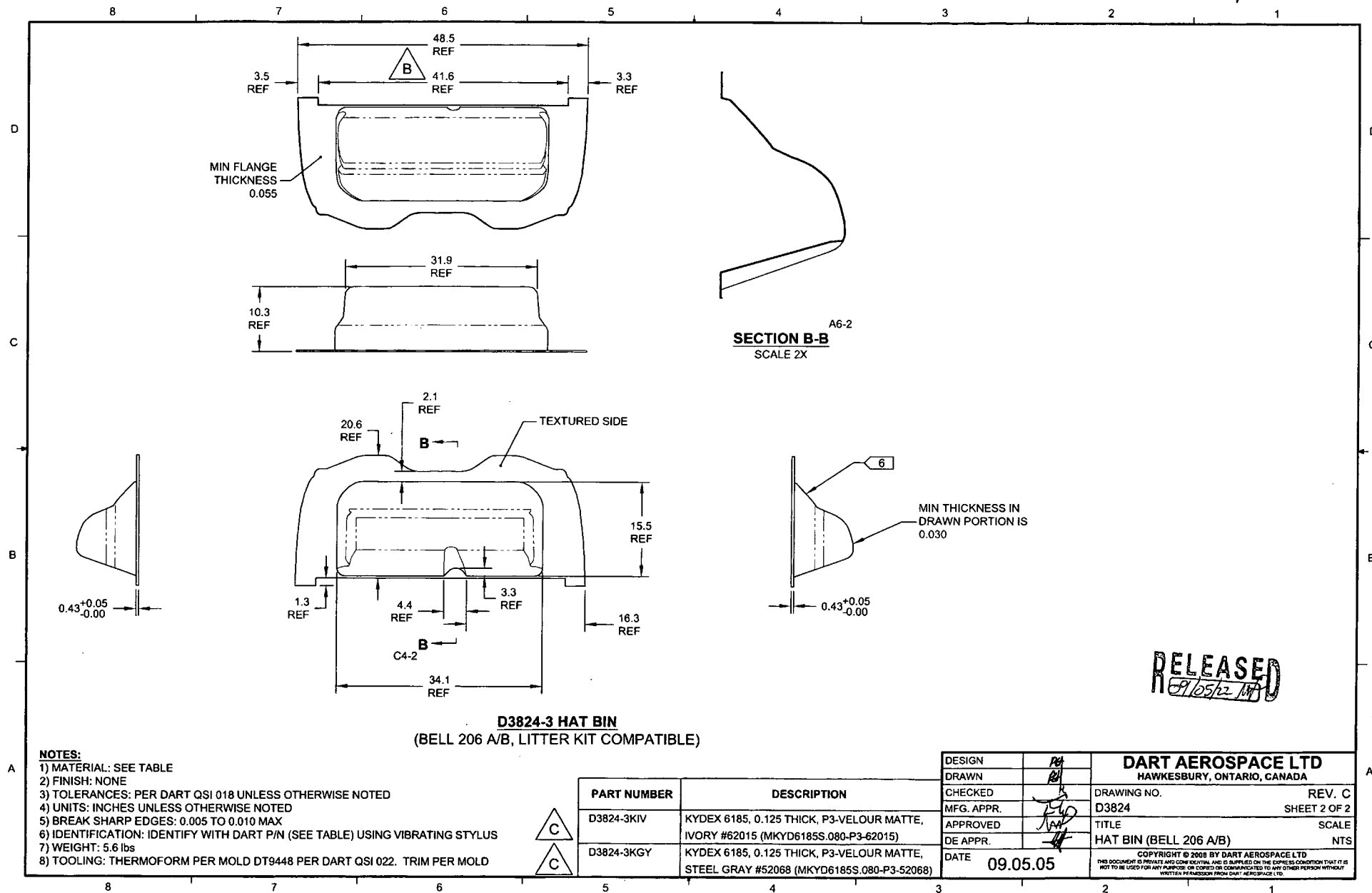
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